

Work Order ID 127969

December-19-14 7:59:04 AM

127969

Page 1

Item ID: D2807-041 Accept ***N9000040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Gas Spring
 Start Date: 12/19/14 Start Qty: 20.00 ***20*** Cust Item ID:
 Required Date: 1/02/15 Req'd Qty: 20.00 ***20*** Customer:
 Reference:

Approvals: Process Plan: CY Date: 14/12/19 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2807	Rev E

100 PURCHASING 0.00
100
 Purchasing Memo 0.00
 Purchasing Issue P/O: 26859 Order as per Dwg D2807Possible
 supplier:Lift Support Technologies,Saskatoon,CanadaP/N 6/15-164/50-115N
 Material release note is required

CY 14/12/19 20

110 Receive & Inspect for Damage & Mat'l Certs 0.00
110
 Packaging Memo 0.00
 Packaging Ensure Material Release Note is attached

20X 8014-12-23

120 QC6- Inspect dimensions to drawing 0.00
120
 QC Memo 0.00
 Quality Control

(20) DAS 38 9-89

JAN 08 2015

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1 27969

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N900040100

Setup Start *NS1*

Stop *NS2*

20

Cust Item ID:

20

Customer:

Reference:

Run Start *NR1*

Stop *NR2*

130

130

Small Fab

Small Fab

Small Fab

Memo

1-install D3671-1 as per dwg D2807

0.00

0.00

140

140

QC

Quality Control

QC5- Inspect part completeness to step on W/O	0.00
---	------

Memo

0.00

0.00

150

150

Packaging

Packaging

Identify as per dwg & Stock Location: JK 012A 0.00

Memo

0.00

0.00

DAG
38
9-89
MAR 09 2015

20 DAS
MAR 10 2015 06
3-89

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Item ID: D2807-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Gas Spring
Start Date: 12/19/14 Start Qty: 20.00 ***20*** Cust Item ID:
Required Date: 1/02/15 Req'd Qty: 20.00 ***20*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

ML5 15-03-11

15-3-10

Picklist Print

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Page 1

Work Order ID: 127969

127969

Parent Item: D2807-041

D2807-041

Parent Item Name: Gas Spring

Start Date: 12/19/14

Required Date: 1/02/15

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP: D 07.11.12 ecn1019, replaces D2807 ECverified by DD
IPP Rev:E 08-02-12 ECN 1111 DD verified by: ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
6/15-164/50-115N		Purchased	No			130	Each	0.0000	1	20			
6/15-164/50-115N										**SP 18-12-23			
Gas Spring													
D3671-1		Manufactured	No			110	Each	1.0000	1	20			
D3671-1										** 15/03/09			
Placard													
						<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>			
						GA		1					
						120617		1					
										B127823 (12)			
										B128427 (7)			

SPECIFICATION CONTROL DRAWING

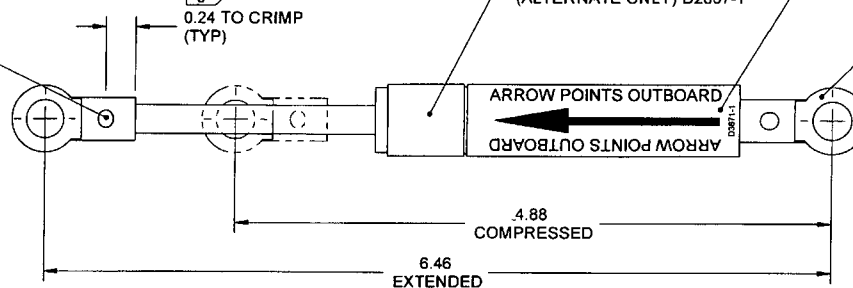
(ALTERNATE ONLY)
CRIMP 0.015-0.025 DEEP
WITH $\phi 0.375$ TOOL AT
2000psi (REF) TYP TWO
SIDES PER LUG

0.24 TO CRIMP
(TYP)

D2807-5
OR
(ALTERNATE ONLY) D2807-1

AFFIX D3671-1 PLACARD
ENSURE PLACARD DOES NOT
CONCEAL ANY TEXT OR MARKINGS
ON THE GAS SPRING

(ALTERNATE ONLY) D2807-3
BOTH ENDS



D2807-041 GAS SPRING

D2807-041 GAS SPRING ASSEMBLY PARTS LIST

QTY -041	PART NUMBER	DESCRIPTION
X	D2807-041	GAS SPRING ASSEMBLY
1	D2807-5	GAS SPRING
1	D3671-1	PLACARD

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.169 LBS
- 8) ALTERNATE PART: D2807-5 CAN BE MADE FROM ASSEMBLING D2807-1 (1) AND D2807-3 (2)
(WEIGHT: 0.176 LBS)

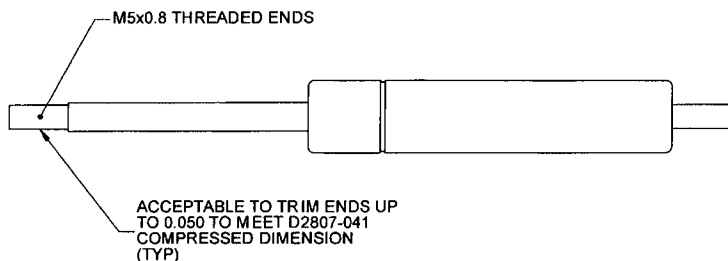
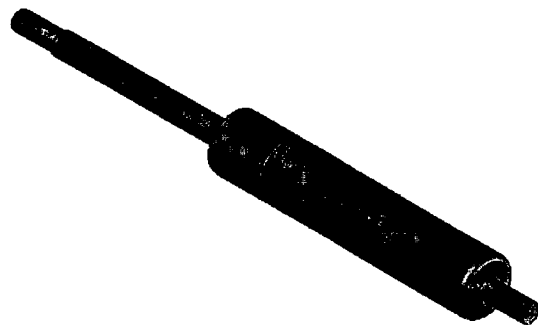


CL 14/12/19
W/O: 127969

RELEASED

E	ADD D2807-5 GAS SPRING; D2807-1/-3 ASSEMBLY IS AN ALTERNATE TO D2807-5 GAS SPRING; UPDATE DIMENSIONS ON D2807-3	PH	07.12.28
D	ADDED D3671-1 PLACARD ADDED -041 ASSEMBLY UPDATED DWG	DC	07.09.27
C	CHANGE SPRING TO SS, ADD -3 LUG	CP	05.05.25
B	ADD FINISH	CP	05.03.16
A	NEW ISSUE	DS	00.11.03
REV.	DESCRIPTION	BY	DATE

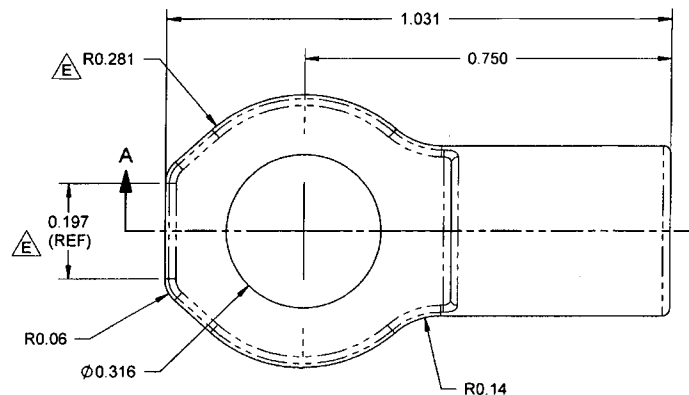
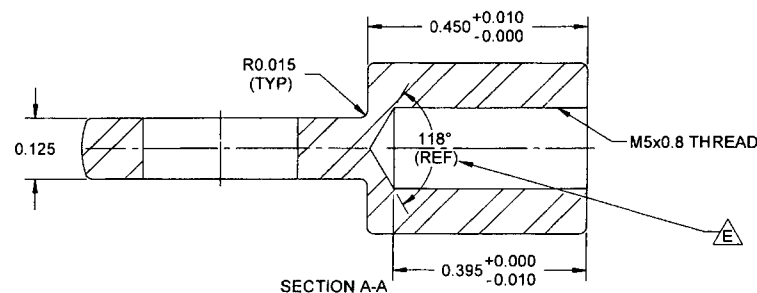
DESIGN	AW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AW		
CHECKED	JE	DRAWING NO. D2807	REV. E
MFG. APPR.	AW	SHEET 1 OF 3	
APPROVED	AW	TITLE GAS SPRING	SCALE NTS
DE APPR.	AW	COPYRIGHT © 2000 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	07.12.28		



D2807-1 GAS SPRING
SCALE 1:1

D2807-1 GAS SPRING NOTES:

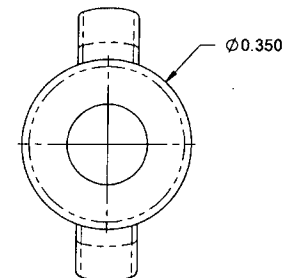
- 1) POSSIBLE SUPPLIER: ARVINMERITOR MOTION CONTROL SYSTEMS, LEICESTER, UK
(P/N SXF6S6050080S6L-115N)
(REF: 80MM LONG CYLINDER, 50MM STROKE, 115N LOAD)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.144 LBS
- 8) SPECIFICATION: SS GAS SPRING
ACCEPTABLE LOAD RANGE IS 25 LB (115 N) MIN TO 45 LB (200 N) MAX
M5x0.8 THREADS



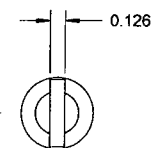
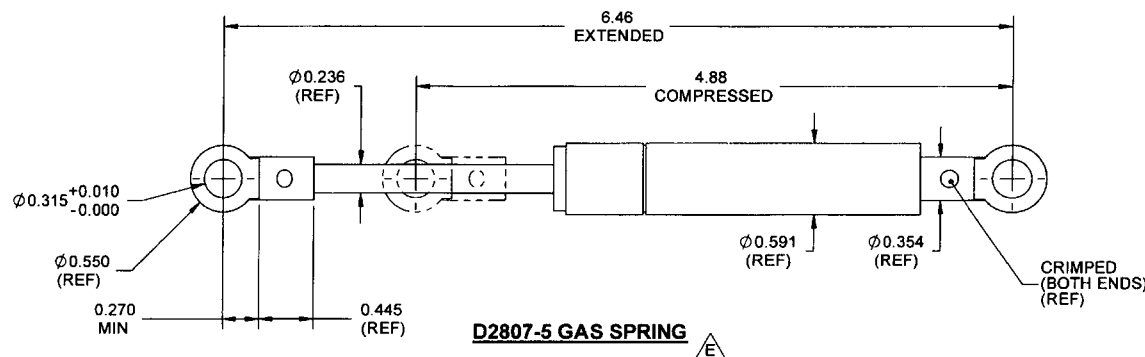
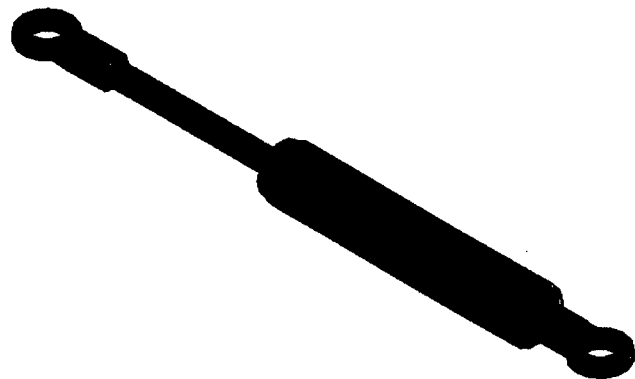
D2807-3 LUG

D2807-3 LUG NOTES:

- 1) MATERIAL: AISI 303 ROUND BAR (REF. DART SPEC. M303R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 TO 0.015
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.016 LBS



DESIGN	PH	DART AEROSPACE LTD	
DRAWN	PH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	LE	DRAWING NO.	REV. E
MFG. APPR.		D2807	SHEET 2 OF 3
APPROVED	PH	TITLE	SCALE
DE APPR.		GAS SPRING	4:1
DATE	07.12.28	COPYRIGHT © 2000 BY DART AEROSPACE LTD	
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D2807-5 GAS SPRING NOTES:

- 1) POSSIBLE SUPPLIER: LIFT SUPPORT TECHNOLOGIES, SASKATOON, CANADA (P/N 6/15-164/50-115N)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.169 LBS
- 8) SPECIFICATION: SS GAS SPRING WITH END FITTINGS.
ACCEPTABLE LOAD RANGE 25 LB (115 N) MIN TO 45 LB (200 N) MAX

DESIGN	PH	DART AEROSPACE LTD	
DRAWN	PH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	HE	DRAWING NO.	REV. E
MFG. APPR.	HE	D2807	SHEET 3 OF 3
APPROVED	HE	TITLE	SCALE
DE APPR.	HE	GAS SPRING	4:1
DATE	07.12.28	COPYRIGHT © 2000 BY DART AEROSPACE LTD	
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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO26859

Purchase Order Date 12/19/2014

PO Print Date 12/19/2014

Page Number 1 of 1

Order From :

VC-LST0001

Ship To : DART AEROSPACE LTD

LS TECHNOLOGIES INC.
314 JESSOP AVE
SASKATOON, SK S7N 1Y6
CA

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone 306 683 5000

Ship To Contact

Ship To Phone

Ship Via: FedEx Overnight collect

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax # 10127-2607

Terms Net 30

Currency CAD

FOB EXW - (Ex Works)

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	6/15-164/50-115N AS PER DWG D2807 REV. E B127969	Gas Spring	12/23/2014 Yes 12/23/2014		20.00 Each	\$63.90	\$1,278.00

Line Total: \$1,278.00

2	71401-45 Procurement Quality Clauses A004 faa-pma/tso A005 right of entry A016 personnel qualification A025 certification of conformance A040 notification of quality escape A043 retention of quality documents	PROCUREMENT QUALITY CLAUSES	12/23/2014 No 12/23/2014		1.00	\$0.00	\$0.00
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Line Total: \$0.00

PO Total: \$1,278.00

PO Instructions: Fedex Acc#151793240

Note: Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Change Nbr: 1

Change Date: 12/19/2014

LS Technologies Inc
314 Jessop Ave
Saskatoon, SK S7N 1Y6

Ph: 306-683-5000 Fax: 306-683-6403

Packing Slip

P.O. No.	Date	Invoice #
26859	12/19/2014	12109

Bill to:
Dart Aerospace Ltd 1270 Aberdeen St. Hawkesbury, ON K6A 1K7

Ship to:
Main Finished Goods Location Dart Aerospace Ltd 1270 Aberdeen St. Hawkesbury, ON K6A 1K7

Ship	Via	FOB
12/19/2014	Fed-Ex	

Qty	Description
20	D2807-041 B126191 Stainless Gas Spring Shipping Via FED EX Tracking # 772324584169 <i>8014-12-23</i>

Order checked by : *78*



LS Technologies Inc

314 Jessop Ave

Saskatoon, SK, S7N 1Y6

Ph: (306) 683-5000 Fax: (306) 683-6403

Certificate of Conformance

Dec 19, 2014

This is to certify that the parts listed below meets specifications as required by your order.

20 Units : D2807-041 B127969 Stainless Gas Spring

Country of Manufacture : Canada

Date of Manufacture : December 2014

This product is ROHS compliant.

Purchase Order # 26859

Inv# 12109

L S Technologies Inc Canada

A handwritten signature in black ink, appearing to be 'Nolan Fehr', written over a horizontal line.

Nolan Fehr
President